

Date: Thursday, 07/05/2009 8:27:33 AM
User: Melanie Fauteux

Process Sheet

Customer	: CC-DAR01 Dart Aerospace Ltd.	Drawing Name	: D206-642-512
Job Number	: 47770		
Estimate Number	: 10804		
P.O. Number	:	Part Number	: D206642512
This Issue	: 07/05/2009 S.O. No. :	Drawing Number	: R09-044
Prsht Rev.	: NC	Project Number	:
First Issue	: / / Type : SKIDTUBES	Drawing Revision	:
Previous Run	: 00015	Material	:
Written By	: <u>090507</u>	Due Date	: 13/05/2009 Qty: 1 Um: Each
Checked & Approved By	: <u>Mf 09-05-07</u>		
Comment	:		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D206642512	Float Skidtube RH
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Float Skidtube RH
Original B35201 @ CHG003

2.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

3.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1
-Dis-assemble the aft cap, and the hardware necessary off of the tube. Keep and clearly identify the hardware removed.
-Drain and remove all LPS 3 on the interior of the tube.
-Polish out any markings that are on the outside surface (check the fwd bent section)

4.0	HAND FINISHING1	HAND FINISHING RESOURCE #1
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Comment: HAND FINISHING RESOURCE #1
-Re-assemble the tube using the original hardware.

If necessary pick and record the hardware needed for re-assembly:

P/N	Batch	Qty
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D2646	1346	327 (x1)
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* SCRAP "1" END-CAP

D2646/1331335

_____	_____	_____
_____	_____	_____
_____	_____	_____
_____	_____	_____
_____	_____	_____
_____	_____	_____

Yf 09-05-13 EX

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 07/05/2009 8:27:33 AM
User: Melanie Fauteux

Process Sheet

Customer: CC-DAR01 Dart Aerospace Ltd.

Drawing Name: D206-642-512

Job Number: 47770

Part Number: D206642512

Job Number:



Seq. #:

Machine Or Operation:

Description :

*** Ensure Melanie does an adjustment in Accpac***

5.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

8 09/05/13 @

Original k642-512 saddle kit B34747 is quarantined at the inspection area for re-packaging.

6.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

New label, decal, and paperwork are required with the new batch # @ CHG003

TWO 09.05.14 (1)

Re-package

Original k642-512 saddle kit B34747 is quarantined at the inspection area for re-packaging

7.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

Ensure original kit is placed back with the correct tube

8 09/05/14 @

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Return to stock

Location: _____

Rev D

8 09/05/14 @

Job Completion



B47770

9.0 QC21

09/05/28

MF 09-05-28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 10/18/2007 8:02:04 AM
 User: Kim Johnston

Process Sheet

45

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : FLOAT SKID RH 206L1,L3,L4&407
 Job Number : 35201
 Estimate Number : 10328
 P.O. Number : N/A Part Number : D206642512
 This Issue : 10/18/2007 S.O. No. : N/A Drawing Number : N/A
 Prsht Rev. : NC Project Number : N/A
 First Issue : N/A Type : LANDING GEAR Drawing Revision : K
 Previous Run : 35200 Material : N/A
 Written By : Due Date : 11/10/2007 Qty: 1 Um: Each
 Checked & Approved By : 10/10/18
 Comment : Est Rev:B 05.09.23 Revised per D206-642 Rev. J KJ/JLM
 Est Rev:C 07-02-23 As per IIN D206-642 Rev K JLM
 est rev D 07.06.06 added K642-512 EC

Additional Product

REFERENCE ONLY

Job Number:



Seq. #: Machine Or Operation: Description :

1.0

DC

DOCUMENT CONTROL



KS 07.10.18

Comment: DOCUMENT CONTROL

Photocopy bluefile and create labels per PPP D206-642-512 CHG003

E. 11/10/01

2.0

35201A

FLOAT SKIDTUBE ASSEMBLY



Comment: Sub-Component FLOAT SKIDTUBE ASSEMBLY

D206-642-541 B 35201A

AS

3.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

4.0

K642 512

saddle kit 642-511



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

saddle kit 642-512

batch: B34747

07/11/01 AS

5.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

E. 11/10/01

DART

TRANSPORT CANADA APPROVAL # 10000

TEL : 1-613-632-3336
FAX : 1-613-632-4443

D206-642-512

CHG

CHG003

Float Skidtube RH

STC

SH98-4

B35201

STC

SA00475SE

206L/L1/L3/L4/407

STC

UNPATENTED
CANADA & FOREIGN PATENTS PENDING

MADE IN CANADA

Form: mprocess

Date: Thursday, 9/20/2007 3:29:05 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : SADDLE KIT FOR D206-642-512
Job Number : 34747	
Estimate Number : 12894	
P.O. Number : N/A	Part Number : K642 512
This Issue : 9/20/2007 S.O. No. : N/A	Drawing Number : N/A
Prsht Rev. : NC	Project Number : N/A
First Issue : N/A Type : LANDING GEAR	Drawing Revision : N/A
Previous Run : 34626	Material : N/A
Written By : <i>[Signature]</i>	Due Date : 10/5/2007 Qty: 4 Um: Each
Checked & Approved By : <i>[Signature]</i>	
Comment : Est Rev: A 05.06.07 new issue EC	

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Photocopy bluefile and create labels per PPP K642-512 CHG003

N/A

2.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

3.0 D206648013 GHW Kit



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number Description Batch

1 D206-648-013 GHW Kit *334627**verified bushings*

4.0 D2652 Bushing



Comment: Qty.: 16.0000 Each(s)/Unit Total : 64.0000 Each(s)

Pick:

Qty Part Number Description Batch

16 D2652 Bushing *226 B33350*

5.0 D2712 Set Screw



Comment: Qty.: 10.0000 Each(s)/Unit Total : 40.0000 Each(s)

Pick:

Qty Part Number Description Batch

10 D2712 Set Screw *33172*

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE KIT FOR D206-642-512

Job Number: 34747

Part Number: K642 512

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

D29322

206 Saddle Right side



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D2932-2

Saddle

B 34064

7.0

D29332

206 Saddle Right



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D2933-2

Saddle

B 33668 (3x)

B 35102

8.0

D2934

Saddle Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

2 D2934

Saddle Spacer

B 34173

9.0

D2935

Saddle Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

2 D2935

Saddle Spacer

B 34003

10.0

D29382

206 Saddle Right side



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D2938-2

Saddle

B 34078

11.0

D29392

206 Saddle Right Side



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D2939-2

Saddle

B 33669

EP 507/10/09 (4)

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE KIT FOR D206-642-512

Job Number: 34747

Part Number: K642 512

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

D33963

Inventory



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

2 D3396-3

Spacer

B 32784 (42) - B 34741 (42) -

13.0

D3407043

Tow Ring



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D3407-043

Tow Ring

B 34639 (24) - B 34011 (x2)

14.0

D34561

washer



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D3456-1

Washer

B 33276 (24) -

15.0

D34571

Inventory



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

2 D3457-1

Washer

B 34640 -

16.0

AN3C35A



Comment: Qty.: 3.0000 Each(s)/Unit Total : 12.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

3 AN3C35A

Bolt

M105036 (72) - M105858 (54) -

17.0

AN3C36A



Comment: Qty.: 9.0000 Each(s)/Unit Total : 36.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

9 AN3C36A

Bolt

M105688 -

07/10/09 (4)

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE KIT FOR D206-642-512

Job Number: 34747

Part Number: K642 512

Job Number:



Seq. #:

Machine Or Operation:

Description :

18.0

AN3C41A



Comment: Qty.: 8.0000 Each(s)/Unit Total : 32.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

8 AN3C41A

Bolt

M105187 -

30X

M105858(2X)

19.0

AN4C6A



Bolt



Comment: Qty.: 12.0000 Each(s)/Unit Total : 48.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

12 AN4C6A

Bolt

M105426 -

20.0

AN5C11A



Comment: Qty.: 8.0000 Each(s)/Unit Total : 32.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

8 AN5C11A

Bolt

M105634 -

21.0

AN5C12A



Comment: Qty.: 4.0000 Each(s)/Unit Total : 16.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

4 AN5C12A

Bolt

M105793 -

22.0

AN5C13A



Comment: Qty.: 4.0000 Each(s)/Unit Total : 16.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

4 AN5C13A

Bolt

M104999 -

23.0

AN5C15A



Bolt



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 AN5C15A

Bolt

M101291 -

07/10/09

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE KIT FOR D206-642-512

Job Number: 34747

Part Number: K642 512

Job Number:



Seq. #:

Machine Or Operation:

Description :

24.0

AN5C32A



EP



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

2 AN5C32A

Bolt

M105156-

25.0

AN5C34A



EP



Comment: Qty.: 2.0000 Each(s)/Unit Total : 8.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

2 AN5C34A

Bolt

M105160-

26.0

AN5C35A



EP



Comment: Qty.: 1.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 AN5C35A

Bolt

M18918-

27.0

AN960C10L

washer



EP



Comment: Qty.: 24.0000 Each(s)/Unit Total : 96.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

24 AN960C10L

Washer

M105143-

28.0

AN960C416L

WASHER



EP



Comment: Qty.: 24.0000 Each(s)/Unit Total : 96.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

24 AN960C416L

Washer

M104936-

EP 07/10/09 (4)

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE KIT FOR D206-642-512

Job Number: 34747

Part Number: K642 512

Job Number:



Seq. #:

Machine Or Operation:

Description :

29.0

AN960C516L

WASHER



Comment: Qty.: 8.0000 Each(s)/Unit Total : 32.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

8 AN960C516L

Washer

M103344

30.0

MS210433

Nut



Comment: Qty.: 20.0000 Each(s)/Unit Total : 80.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

20 MS21043-3

Nut

M105728

31.0

MS210434

Nut



Comment: Qty.: 13.0000 Each(s)/Unit Total : 52.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

13 MS21043-4

Nut

M105930

32.0

MS210435

Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total : 16.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

4 MS21043-5Nut

M105054

33.0

NAS1515H3L

WASHER



Comment: Qty.: 24.0000 Each(s)/Unit Total : 96.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

24 NAS1515H3L

Washer

M105728 (891)M105057 (7X)

34.0

NAS1515H4L

WASHER



Comment: Qty.: 24.0000 Each(s)/Unit Total : 96.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE KIT FOR D206-642-512

Job Number: 34747

Part Number: K642 512

Job Number:



Seq. #:

Machine Or Operation:

Description :

24 NAS1515H4L Washer

M105408

35.0

NAS1515H5

Washer



Comment: Qty.: 16.0000 Each(s)/Unit Total : 64.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

16 NAS1515H5

Washer

M105728

36.0

NAS1515H5L

WASHER



Comment: Qty.: 8.0000 Each(s)/Unit Total : 32.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

8 NAS1515H5L

Washer

M104956

37.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

placed in plastic boxes for packaging.

38.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP K642-512 CHG003

Location:

39.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

F 10/10/16

Job Completion



W 10/10/15